

13/11

Work Order ID 53683

November 12, 2009 9:13:35 AM



PRELIMINARY ISSUE

Item ID: D4013-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly

Stop



Start Date: 11/12/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

EW

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4013

B-PRELIM

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4013-1

Dwg Rev:

PRE

Prog Rev:

Lim

2-Deburr if necessary

18 9-11-12

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

18 9-11-12

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Customer:

Reference:

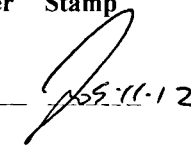
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts - second check	0.00				2			
QC Quality Control	Memo	0.00							
130 	Bend as per dwg	0.00				2	0		
Brake NC Brake NC	Memo	0.00							
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

SB 09/11/12

Log 11.12 (2x)
PTG.

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 		0.00							
Large Fab									
Large Fab	Memo Weld cup, stud and apply hardfacing as per dwg A/R S.S. ROD BATCH: <u>M108775</u> A/R HARDCOAT 2059B BATCH: <u>M112963</u>	0.00							
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	Memo	0.00							
170 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	Memo	0.00							

SP/ 09 11 B (IX)
09/11/13

1 09/11/13

09/11/13

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Item ID: D4013-041

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Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo	0.00							
190 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
200 	Identify as per dwg & Stock Location	0.00							
Packaging Packaging	Memo	0.00							

PART REQ'D FOR FIT & TESTING
PURPOSES ON PART + OEM
SKID TUBES.
DO NOT STOCK.

KEEP FOR
ENG/R&D USE.

11.11.26

POSITIVE RECALL
EFFECTIVE 11/12/09 AUTH
RELEASED _____ DATE _____

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Item ID: D4013-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate Assembly

Start Date: 11/12/09 Start Qty: 1.00

Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PL 0911-27
②
R10324ANW

Picklist Print

November 12, 2009 9:13:35 AM

Page 1

Work Order ID: 53683

Parent Item: D4013-041

Parent Item Name: Wearplate Assembly

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
RevB prelim per ECN09-698p 09.11.02 DD verified
by:EC
redesign 09.11.12 DD verified by:EC

IPP RevB:

IPP RevC:

Start Date: 11/12/09

Start Qty: 1.00

Required Date: 11/13/09

Required Qty: 1.00

M304S16GA

Purchased

No

100

sf

201.3664

1.0211

2.0422



304/316 Sheet .063

B 9-11-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

201.3663737

106860

16.018

111924

25.1689737

112442

32.0821

112567

0.2973

112885

127.8

112442

2

D4013-3

Manufactured

No

150

Each

20.0000

3.0000



Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

53183

53669

20

20

150

Each

0.0000

6.0000

3x

8p 09.11.12.

D4013-5

Manufactured

No



Cup

D4013-9

Manufactured

No



Stud

D4013-11

Manufactured

No



Stud

B 53670

6x

B 53671

2x

B 53672

2x

8p 09.11.13.

8p 09.11.12.

8p 09.11.12.

DART AEROSPACE LTD		Work Order: 53683
Description: WEAR PLATE ASSEMBLY		Part Number: D4013-041
Inspection Dwg: D4013-1 Rev: PRE Lim		Page 1 of 1

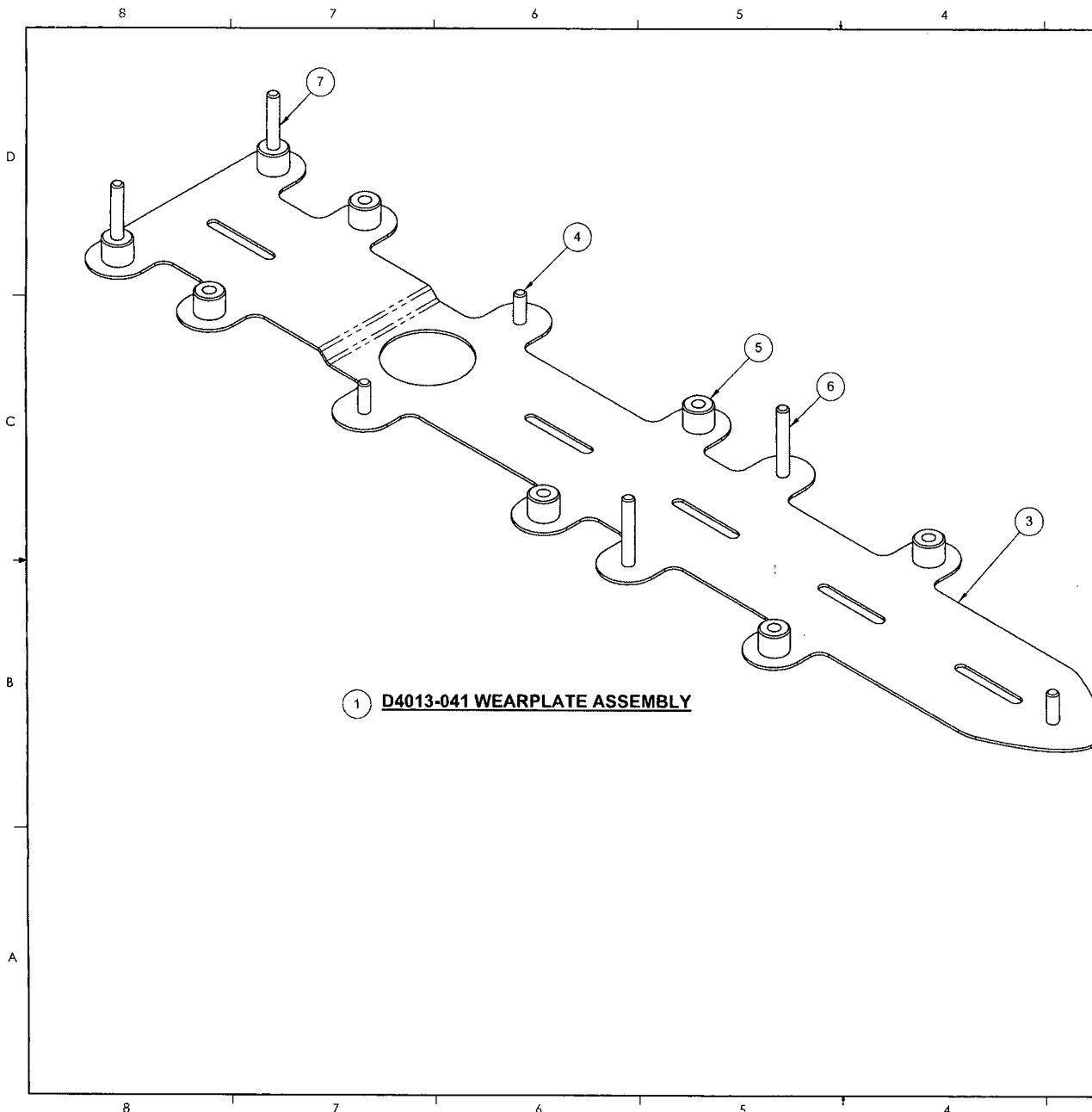
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .250	+ .005 - .001	.253	✗			
Ø .625	+ .008 - .001	.629	✗			
Ø 1.88	+ .012 - .001	1.881	✗			
1.50	± .030	1.500	✗			
2.125	± .010	2.128	✗			
2.75	± .030	2.746	✗			
1.750	± .010	1.754	✗			
.625	± .010	.621	✗			
3.125	± .010	3.123	✗			
7.063	± .010	7.061	✗			
7.458	± .010	7.457	✗			
12.333	± .010	12.333	✗			
14.646	± .010	14.646	✗			
18.646	± .010	18.646	✗			
24.146	± .010	24.146	✗			
25.23	± .030	25.230	✗			
.063	± .010	.060	✗			

Measured by: LB	Audited by: [Signature]	Prototype Approval: N/A
Date: 9-11-12	Date: 9-11-12	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



1 D4013-041 WEARPLATE ASSEMBLY

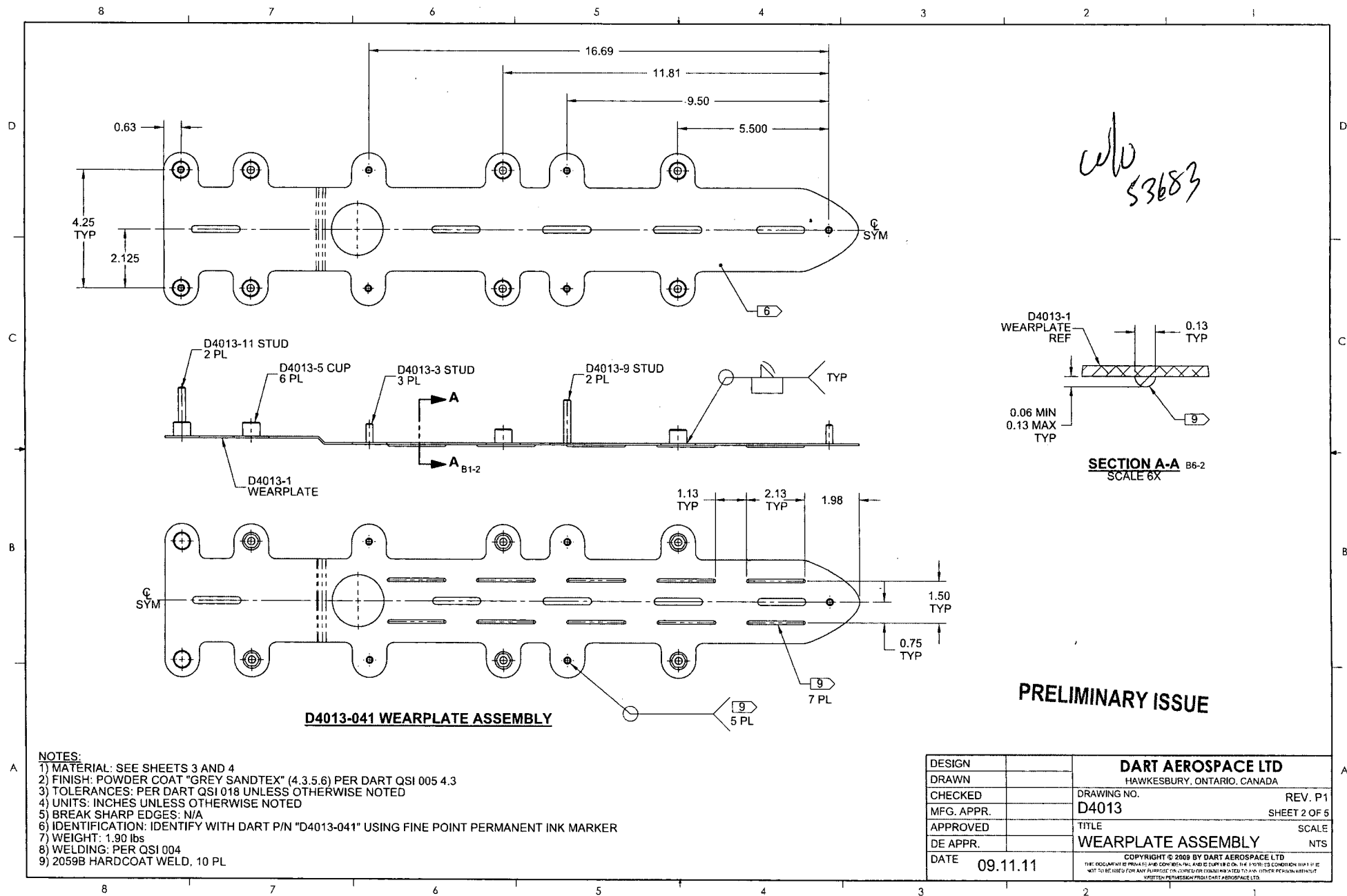
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

W/O
53683

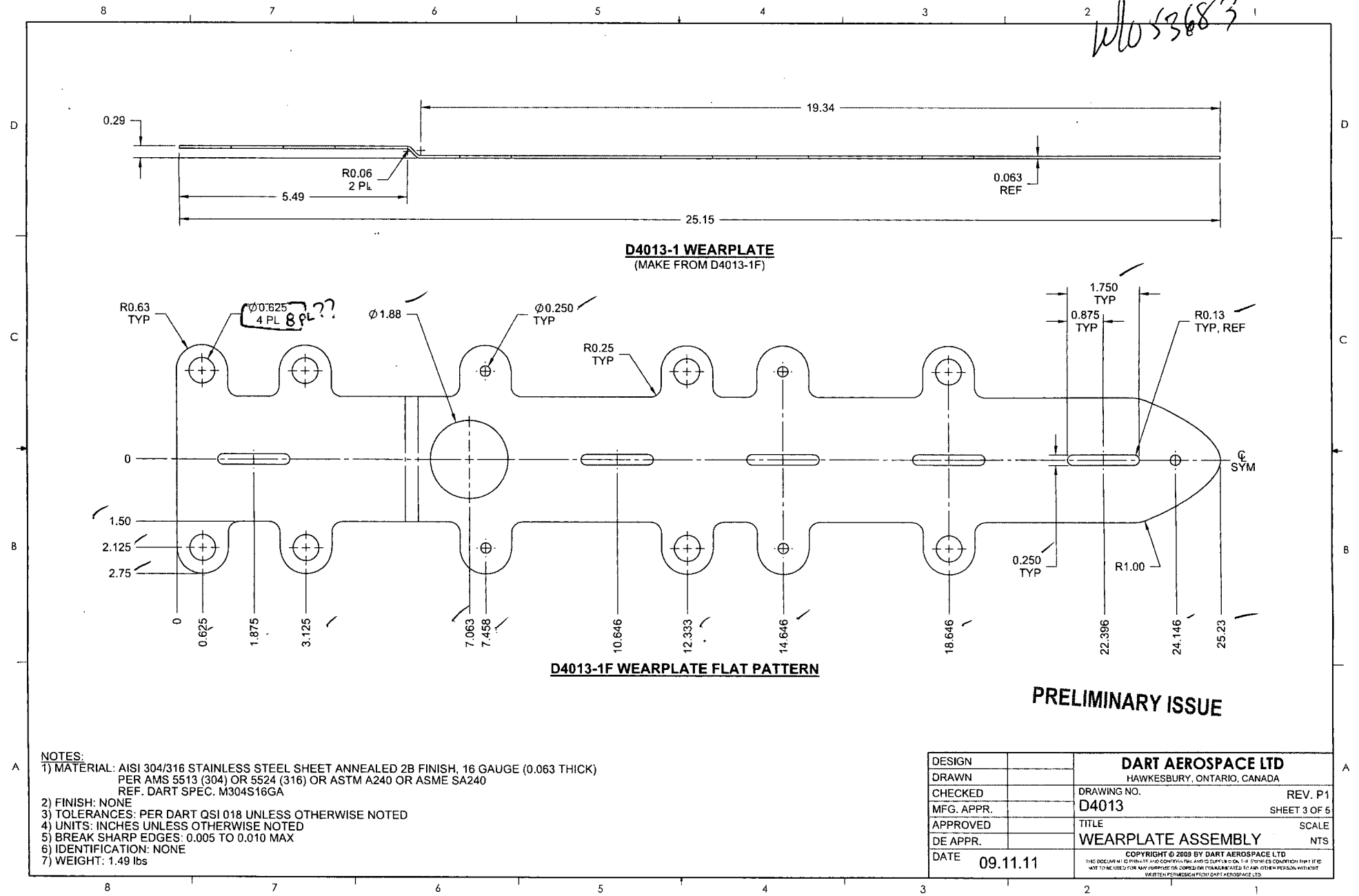
PRELIMINARY ISSUE

P1	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5: ELIMINATED D4013-7 CUP (NO LONGER USED)	MB	09.11.10
B	REDESIGN	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4013	REV. P1 SHEET 1 OF 5
TITLE WEARPLATE ASSEMBLY	SCALE NTS
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WLO 53683



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.49 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. P1
MFG. APPR.		D4013	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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